DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027829
Date Inspected: 23-Jun-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: jobsite

CWI Name:	Steve Jensen, William Sherwood			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

OBG W13-W14 Splice West Drop-in

QAI observed the back welding of deck splice 13W-14W-W2.1 by welder Mike Jiminez in the 4G position utilizing the Shield Metal Arc Welding (SMAW)Process. E7018 consumable electrode was being used to the QC recorded QAI randomly verified parameters of Welding Procedure Specification ABF-WPS-D15-1040C-CV. The welder was using a stringer technique to fill in the back-gouge. A power wire brush and manual chipping hammer was being used to clean between passes.

This QAI observed the welding of the floor beam L8-5W by Welder Rory Hogan in the 3G position utilizing the Shield Metal Arc Welding (SMAW)Process. E7018 consumable electrode was being used to the QC recorded QAI randomly verified parameters of the applicable Welding Procedure Specification. The welder was using a stringer technique to fill in the back-gouge. A power wire brush and manual chipping hammer was being used to clean between passes. Welding is 80% complete on the above-mentioned weld.

Numerous techniques are being used by the contractor to correct planer misalignment on the floor beams. One example is tack welding strong backs on to the beam flange and driving wedges to position the the material into

place for welding. (See pictures) Another method is to use a porta power hydraulic ram to reposition the flange then tacking strong backs followed by welding in the finished weld joint. (See pictures)

Summary of Conversations:

There were general conversations with Quality Control Inspector Steve Jensen, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to Danny Reyes and Bill Levell.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

Inspected By:	Daggett,Matt	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer